Date: Wednesday, 4/4/2007 9:10:10 AM
User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31639
Estimate Number : 12815
P.O. Number : N/A
This Issue : 4/4/2007 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : PURCHASED PARTS
Previous Run : N/A
Written By : EC
Checked & Approved By :
Comment : Est. A 07.04.04 new issue EC

Drawing Name : CHAFING SHIELD
Part Number : D31893
Drawing Number : D3189 UNDER REVIEW
Project Number : N/A
Drawing Revision : U/R
Material : N/A
Due Date : 4/11/2007 **Qty:** 2 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET

Comment: Qty.: 0.2205 sf(s)/Unit Total : 0.4410 sf(s)
304/316 SS .020" Sheet
(M304S25GA)
Batch: M102393
SB 07/04/04 (2)

2.0	SHEAR	SHEAR

Comment: SHEAR
Cut to size as per Dwg D3189
SB 07/04/04 (2)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr & Grind Rads as per Dwg D3189

2-Roll as per Dwg D3189
SB 07/04/04 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL
07.04.04

Comment: INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1

07.04.04 (2)

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: L.G. for ASS'Y

Form: rprocess

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 31639

Part Number: D31893

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion

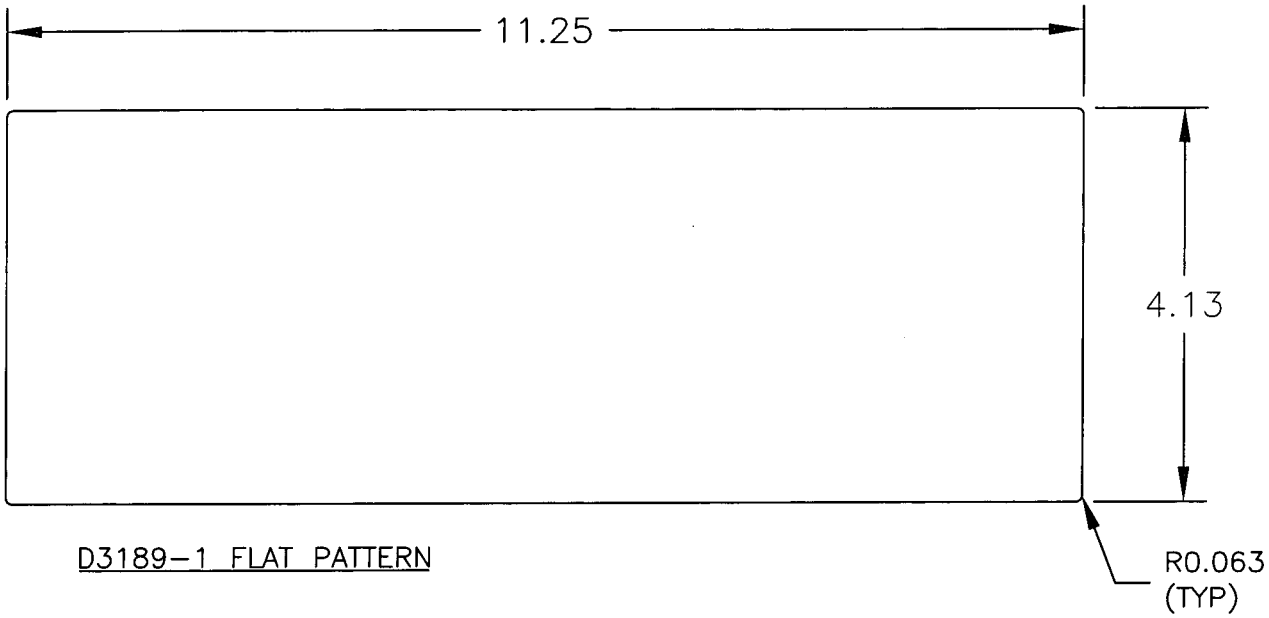
il 07.04.04

Form: rprocess

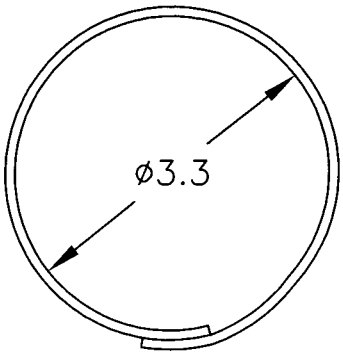
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

A	03.05.08	NEW ISSUE
B	07.01.05	ADD −3



D3189−1 FLAT PATTERN



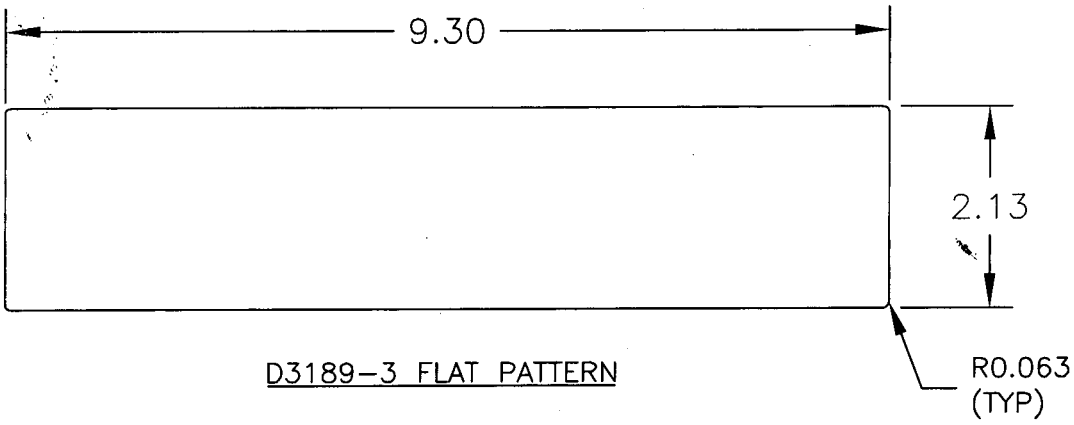
D3189−1 ROLLING DETAIL
NOT TO SCALE

D3189−1 CHAFING SHIELD

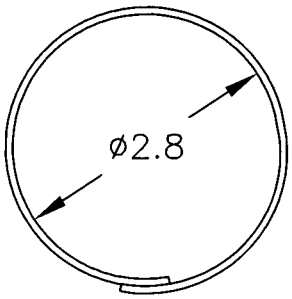
1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
2) FINISH: NONE
3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2



D3189-3 FLAT PATTERN



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
2) FINISH: NONE
3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES